

Date: Wednesday, 11/03/2009 11:25:38 AM  
 User: Chantal Lavoie

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206 A/B LOW GEAR WEB		
Job Number	: 46425					
Estimate Number	: 11768					
P.O. Number	:			Part Number	: D26541	
This Issue	: 11/03/2009		S.O. No. :	Drawing Number	: D2654 REVE1	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /		Type :	Drawing Revision	: E1	
Previous Run	: 44279			Material	:	
Written By	:			Due Date	: 18/03/2009	
Checked & Approved By	: <u>CDL0910311</u>			Qty:	2 Um: Each	
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM Est Rev:E 08-06-10 revE1 as per dwg DD verified by:EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D26005108	Extrusion 'I Beam' thin	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
	Qty	Part Number	Description
	1	D2600-5	Batch Web 109-3-11
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1	
		Comment: LANDING GEAR RESOURCE 1	
		1-Cut D2600-5 to length as per Dwg D2654 (73.85")	
		2-Drill pilot holes in web using drill jig DT 8018-1 as per Dwg D2654	
		3-Using the uni-bit, open holes to finish size as per Dwg D2654	
		4-Deburr holes and ends	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Acid etch and Alodine as per QSI 005 4.1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206 A/B LOW GEAR WEB

Job Number: 46425

Part Number: D26541

Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
6.0	PACKAGING 1	PACKAGING RESOURCE #1
7.0	QC21	FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

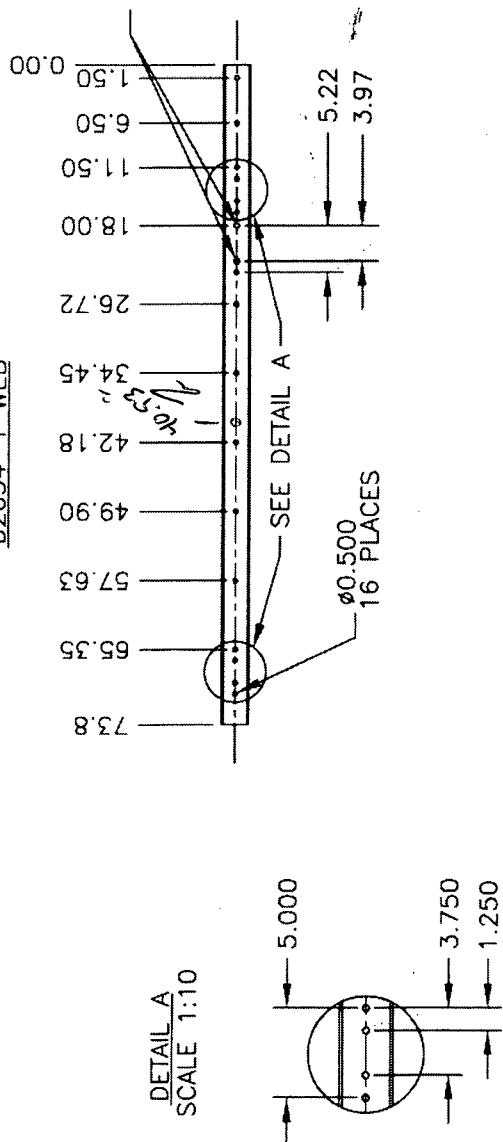
0.070° off center



DESIGN <i>fp</i>	DRAWN BY <i>fp</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED <i>fp</i>	APPROVED <i>fp</i>	DRAWING NO. D2654	REV. E	SHEET 1 OF 2
DATE 04.05.26	TITLE WEB		SCALE 1:20	

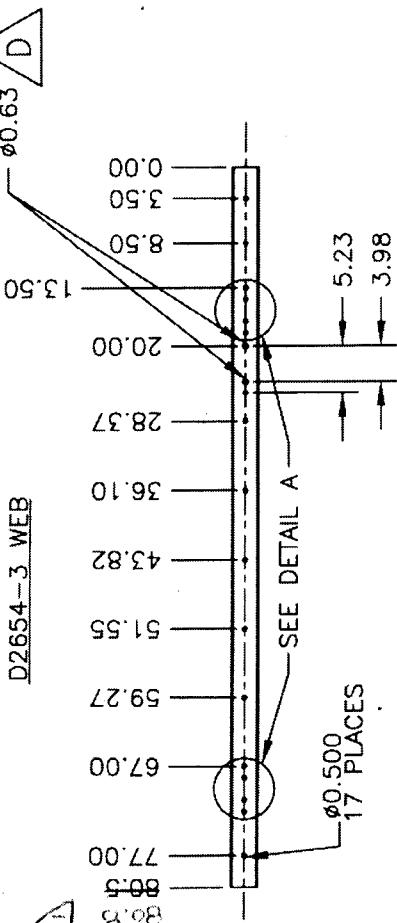
04.06.22 97

D2654-1 WEB



DETAIL A  
SCALE 1:10

D2654-3 WEB



W10: 46425  
C809/03/11

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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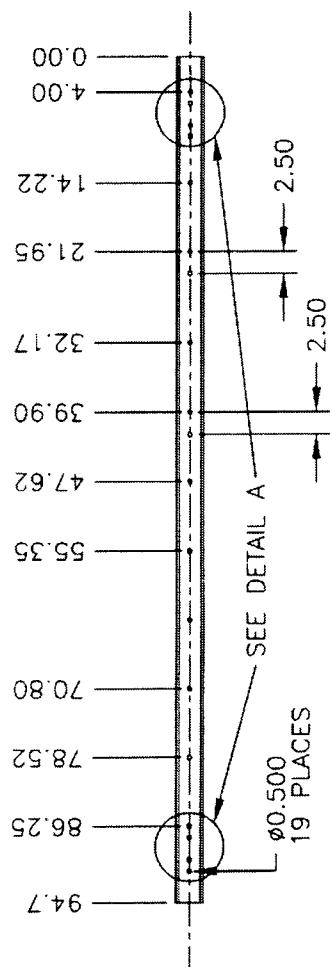
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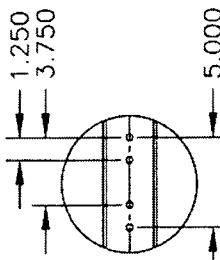
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E
DATE		SHEET 2 OF 2
04.05.26		TITLE WEB
		SCALE 1:20

RELEASED  
22.04.00

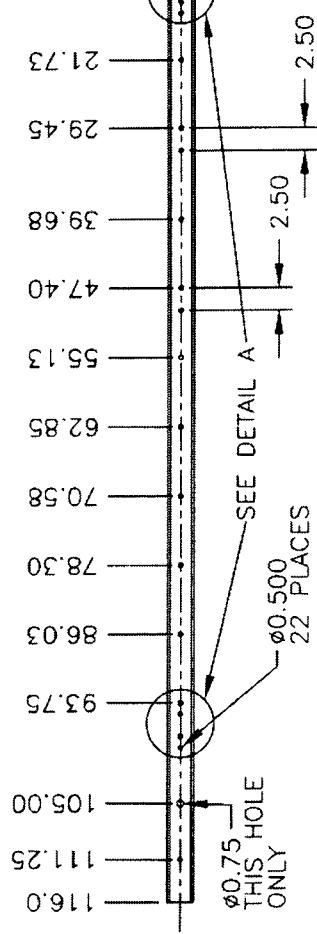
D2654-5 WEB



DETAIL A  
SCALE 1:10



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W10: 46425

0209/03/11

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